

SHIP MON OCT 31

Work Order ID 75663-1

October-27-11 2:41:07 PM

SPLIT

\*75663\*

Page 1

Item ID: D2662-2

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle, RH In 206

Start Date: 10/27/11 Start Qty: 11.00

\*11\*

Cust Item ID:

Required Date: 11/01/11 Req'd Qty: 11.00

\*11\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2662

Rev D.

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.  
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 & DWG

DWG REV: B

FOLIO REV: AA

110

0.00

\*110\*

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 11-10-30

(B)

Pro

SL 11-10-30

3

W/O: 75663-1

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2662-2 PAR #: N/A - Fault Category: Machining NCR: Yes No DQA: ✓ Date: 11-11-03  
 Resolution: Use as is Disposition: Use as is QA: N/C Closed: ✓ Date: 11-11-04

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.10.31	100	PER FAI SHEET, SADDLES #1, #2, AND #6 ARE OFF TOL. AS FOLLOWS: 0.150/0.152/0.150 W L100			SL 11-10-31	0		
		OF 0.100/0.140. MEASURES 0.157/0.160/0.160. SADDLES WERE INSTALLED ON SLIDING/CROSTUB WITH	11.10.31 CS1002	ACCEPTABLE DEVIATION.		OK 11/10/31		11/10/31
		DOUBT + SPACERS FOR VERIFICATION. INSTALL OK. R.C. program process						

NOTE: Date &amp; initial all entries

# Work Order ID 75663

**\*75663\***

Page 2

October-27-11 2:41:07 PM

Item ID: D2662-2

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, RH In 206

Stop **\*NS2\***

Start Date: 10/27/11 Start Qty: 11.00 **\*11\***

Cust Item ID:

Required Date: 11/01/11 Req'd Qty: 11.00 **\*11\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start <b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop <b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		SL 11-10-30		3			
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		OK 11/10/31		3			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				3			OK 11-10-31.

**\*75663\***

October-27-11 2:41:07 PM

**Accept**

\*N900040100\*

Setup Start \*MIC 1\*

Stop \*NS2\*

**Item Name:** Saddle, RH In 206

**Start Date:** 10/27/11      **Start Qty:** 11.00      **\*11\***

**Cust Item ID:**

**Required Date:** 11/01/11      **Req'd Qty:** 11.00      **\* 1 1 \***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run Start** **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
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**\*150\***

Powdercoat

## Powder Coating

## Memo

START TIME:

FINISH TIME: \_\_\_\_\_

OVEN TEMPERATURE:

160	QC3- Inspect Part Finish	0.00
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**\*160\***

QC

## Quality Control

## Memo

170	Identify as per dwg & Stock Location:	0.00
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\*170\*

### Packaging

## Packaging

**Work Order ID 75663****\*75663\***

Page 4

October-27-11 2:41:07 PM

Item ID: D2662-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Saddle, RH In 206

Stop **\*NS2\***

Start Date: 10/27/11 Start Qty: 11.00

**\*11\***

Cust Item ID:

Required Date: 11/01/11 Req'd Qty: 11.00

**\*11\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


**\*180\***

QC

Memo

0.00

Quality Control

11/11/01   
ME  
11-11-01

# Picklist Print

October-27-11 2:41:06 PM

Page 1

Work Order ID: 75663

Parent Item: D2662-2

Parent Item Name: Saddle, RH In 206

Start Date: 10/27/11

Required Date: 11/01/11

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet		Manufactured	No			100	Each	271.0000	1	11			

JL 11-10-30

Location	Loc Qty	Loc Code
MAT040	271	
66965	1	
69677	2	
73774	60	
73779 ✓	60	14
74648	80	
74679	68	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	75663
<b>Description: 206 Saddle, Inboard, Right side</b>	<b>Part Number:</b>	D2662-2
<b>Inspection Dwg: D2662 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	* Date
				1	2	3	4		
A	0.100	0.140		-121	-126	-120	-130	121	120
B	0.100	0.140		-150	-152	-131	-131	-127	-150
C	1.125	1.145		1.134	1.135	1.140	1.136	1.137	1.135
D	0.615	0.685		.680	.680	.680	.680	.680	.680
E	0.240	0.260		.250	.254	.251	.254	.252	.252
F	1.313	1.343		1.323	1.327	1.328	1.328	1.327	1.325
G	0.210	0.230		.224	.221	.222	.223	.222	.220
H	0.100	0.180		.130	.130	.130	.130	.130	.130
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
J	1.565	1.585		1.574	1.575	1.579	1.576	1.577	1.575
K	0.235	0.240		.237	.238	.238	.238	.238	.238
L	0.100	0.120		.114	.113	.113	.113	.113	.113
M	0.990	1.010		.990	.990	.990	.990	.990	.990
N	0.510	0.515		.512	.512	.512	.512	.512	.512
O	5.990	6.010		5.996	5.996	5.995	6.003	6.004	6.000
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318		.313	.313	.313	.313	.313	.313
S	0.315	0.322		.316	.316	.316	.316	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.797	.794	.794	.795	.799	.797
W	0.540	0.560		.549	.549	.550	.549	.550	.549
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262		.257	.257	.257	.257	.257	.257
Z	0.912	0.932		.919	.921	.919	.922	.924	.922
AA	0.490	0.510		.498	.498	.497	.502	.502	.500
AB	0.178	0.198		.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-10-29

Audited by:	my
Date:	11/10/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22662
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2662-2
<b>Inspection Dwg:</b> D2662 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.120	.120	.121
B	0.100	0.140		.135	.135	.135	.135	.132	.134
C	1.125	1.145		1.136	1.135	1.136	1.139	1.138	1.138
D	0.615	0.685		.680	.680	.680	.680	.680	.680
E	0.240	0.260		.252	.251	.251	.249	.249	.249
F	1.313	1.343		1.327	1.324	1.324	1.324	1.324	1.324
G	0.210	0.230		.222	.220	.220	.220	.220	.220
H	0.100	0.180		.130	.130	.130	.130	.130	.130
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490	2.490
J	1.565	1.585		1.576	1.575	1.576	1.579	1.578	1.578
K	0.235	0.240		.238	.238	.238	.238	.238	.238
L	0.100	0.120		.113	.113	.113	.113	.113	.113
M	0.990	1.010		.990	.990	.990	.990	.990	.990
N	0.510	0.515		.512	.512	.512	.512	.512	.512
O	5.990	6.010		6.004	6.004	6.004	6.004	6.004	6.004
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
R	0.313	0.318		.313	.313	.313	.313	.313	.313
S	0.315	0.322		.316	.316	.316	.316	.316	.316
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362	1.362
V	0.787	0.807		.799	.799	.799	.800	.799	.799
W	0.540	0.560		.550	.550	.550	.550	.550	.550
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679	1.679
Y	0.257	0.262		.257	.257	.257	.257	.257	.257
Z	0.912	0.932		.922	.923	.923	.923	.922	.922
AA	0.490	0.510		.502	.502	.502	.502	.501	.502
AB	0.178	0.198		.188	.188	.188	.188	.188	.188
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>2</u>	Audited by: <u>mk</u>
Date: <u>11-10-99</u>	Date: <u>11/10/30</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>75663</b>
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	<b>D2662-2</b>
<b>Inspection Dwg:</b> D2662 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				<del>1</del> 13	<del>2</del> 14	<del>3</del> 1	<del>4</del> 0		
A	0.100	0.140		.120	.121				
B	0.100	0.140		.135	.135				
C	1.125	1.145		1.139	1.140				
D	0.615	0.685		.680	.680				
E	0.240	0.260		.250	.250				
F	1.313	1.343		1.325	1.325				
G	0.210	0.230		.220	.221				
H	0.100	0.180		.130	.130				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.579	1.580				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.113	.113				
M	0.990	1.010		.990	.990				
N	0.510	0.515		.512	.512				
O	5.990	6.010		6.004	6.004				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.313	.313				
S	0.315	0.322		.316	.316				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.799	.799				
W	0.540	0.560		.549	.550				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.257	.257				
Z	0.912	0.932		.924	.923				
AA	0.490	0.510		.502	.502				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-10-30

Audited by:	CMK
Date:	11/10/30

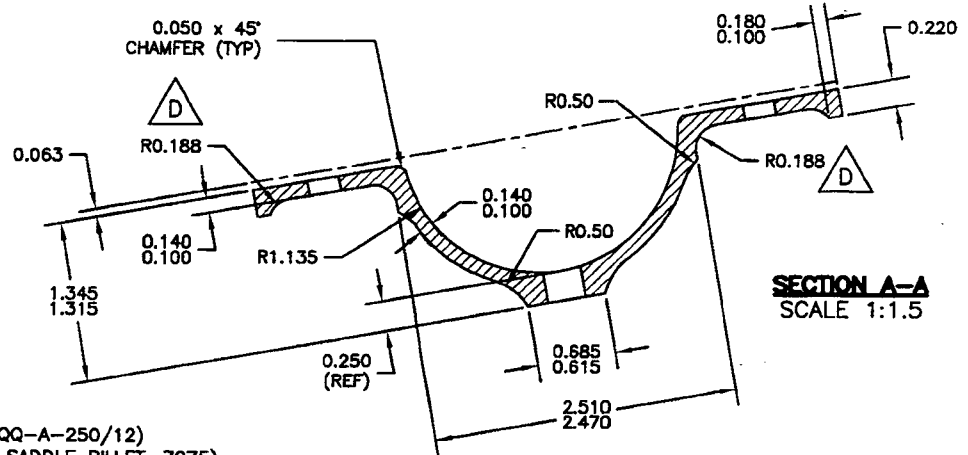
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

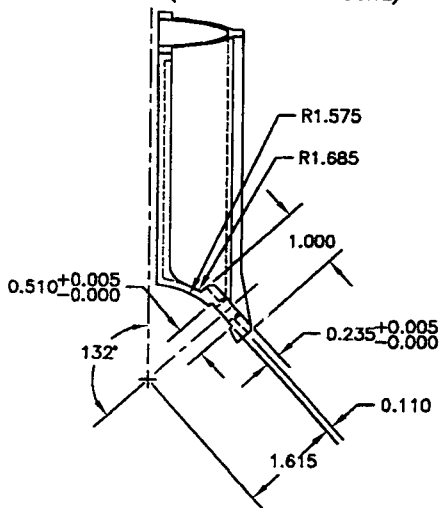
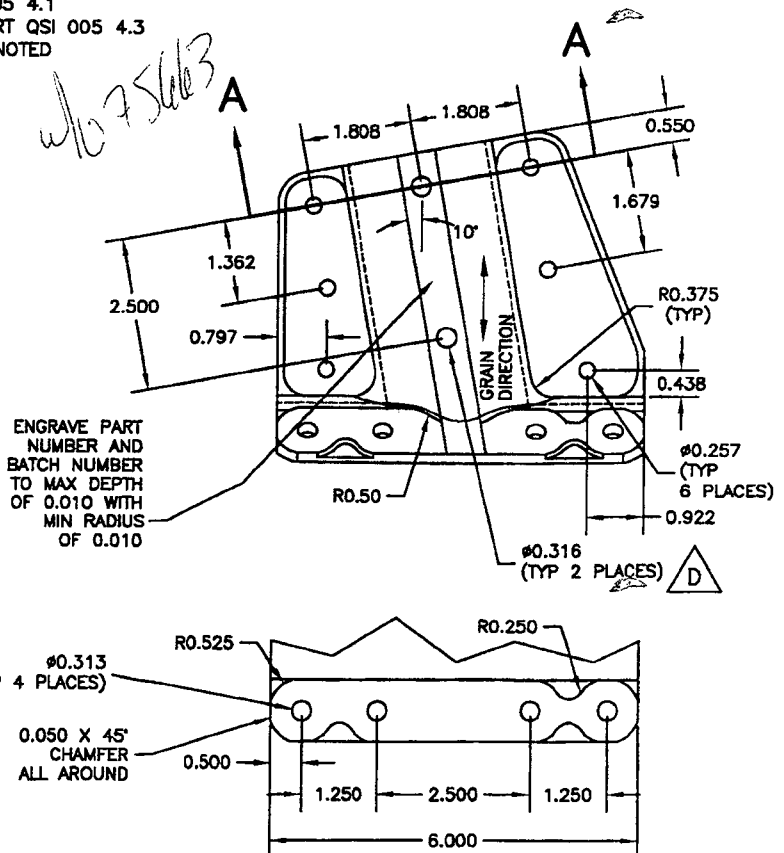
DESIGN <b>A</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2662	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE INSIDE	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORP' DEO 9122/9102/9095/9137	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

RELEASED

07.02.02

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) D2662-1 SHOWN (D2662-2 IS OPPOSITE)

**D2662-1 SADDLE INSIDE**

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